

Date: Wednesday, 3/14/2007 3:33:22 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 31234		
Estimate Number	: 12468		
P.O. Number	: <i>N/A</i>	Part Number	: D35041
This Issue	: 3/14/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3504 REV B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: 3/14/2007 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 31230	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 3/21/2007
Checked & Approved By	: <i>[Signature] 07.03.15</i>	Qty:	<i>50</i> Um: Each
Comment	: Est Rev:A New Issue 06-06-20 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0500W049	6061-T6 Tube .500 x.049W
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Comment: Qty.: 0.2972 f(s)/Unit Total : 7.4288 f(s)  
 6061-T6 Tube .500 x.049W  
 (M6061T6T500W049)  
 Batch: *M 103763*

*J.F. 07/03/22*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
 1-TURN AS PER FOLIO FA642 & DWG D3504,  
 FOLIO REV: *[Signature]*  
 DWG REV: *[Signature]* *New prog.*

2-DEBURR AS REQUIRED

*J.F. 07/03/22**(50)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 07/03/22**(50)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.L. 07/03/22**(50)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

*[Signature] 7/3/22**[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date: 07/03/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:33:23 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 31234

Part Number: D35041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



52

Comment: FINAL INSPECTION/W/O RELEASE

207/03/26

Job Completion



U 07-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

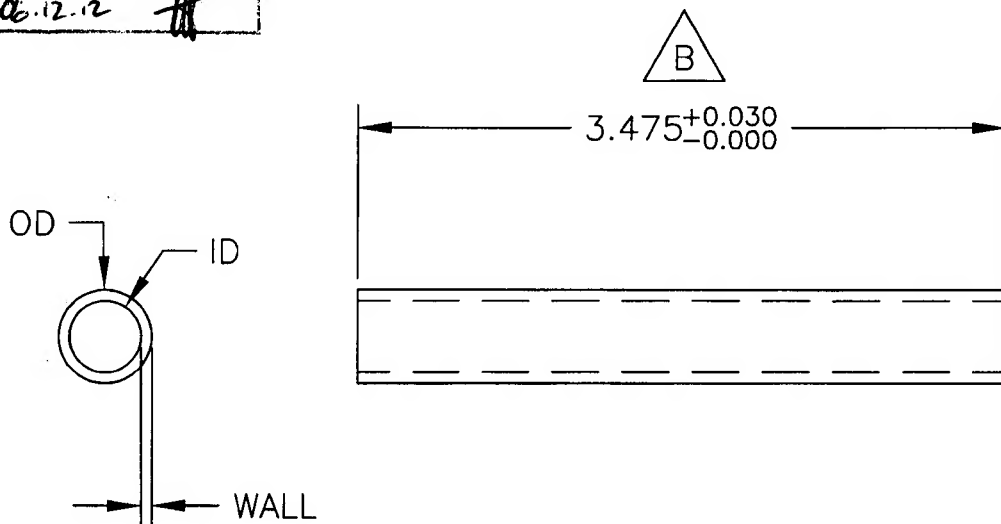




DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3504	REV. B SHEET 1 OF 1
DATE 06.11.01		TITLE CROSS BOLT SPACER	SCALE 1:1
A	06.04.21	NEW ISSUE	
B	06.11.01	3.475 WAS 3.400	

RELEASED

06.12.12 *[Signature]*



**D3504-1/-3 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3504-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3504-3	0.375	0.049	0.277	M6061T6T0.375W.049

**D3504-1/-3 CROSS BOLT SPACER**

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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